

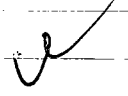
ASAP

Work Order ID 77781

\*77781\*

December-21-11 9:19:09 AM

Item ID: D6102-013 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: Saddle Billet  
Start Date: 12/21/11 Start Qty: 40.00 \*40\* Cust Item ID:  
Required Date: 12/29/11 Req'd Qty: 40.00 \*40\* Customer:  
Reference:

Approvals: Process Plan:  Date: Tooling: Date: Run Start \*NR1\*  
QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D6102	Rev D

100 PURCHASING 0.00

\*100\*

Purchasing

Purchasing

Memo

0.00

Issue P/O: 15716 a) Description: Aluminum Billet(b) 7.000" x 6.500" x 2.000" thick(c) Tolerance on all dimensions is +0.06/0.00d) Grain direction along 6.500" length(e) Material: 6061-T6/T6511 (QQ-A-250/11 or QQ-A-200/8)Material release certifi

11-12-21  
(40)

110 Receive & Inspect for Damage & Mat'l Certs 0.00

\*110\*

Packaging

Packaging

Memo

0.00

Ensure material certification is attached

6/2/12 (48)

120 QC6- Inspect dimensions to drawing 0.00

\*120\*

QC

Quality Control

Memo

0.00

Check certification to Dwg D6102 for compliance

12/01/31 (40)

# Work Order ID 77781

**\*77781\***

Page.2

December-21-11 9:19:09 AM

Item ID: D6102-013 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle Billet  
 Start Date: 12/21/11 Start Qty: 40.00 **\*40\*** Cust Item ID:  
 Required Date: 12/29/11 Req'd Qty: 40.00 **\*40\*** Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>NATYY</u>	0.00							
<b>*130*</b>									
Packaging	Memo	0.00				40			
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

12/21/11 *[Signature]*  
 12-01-31  
 40

# Picklist Print

December-21-11 9:19:09 AM

Page 1

Work Order ID: 77781

Parent Item: D6102-013

Parent Item Name: Saddle Billet

Start Date: 12/21/11

Required Date: 12/29/11

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 06-07-03 JLM

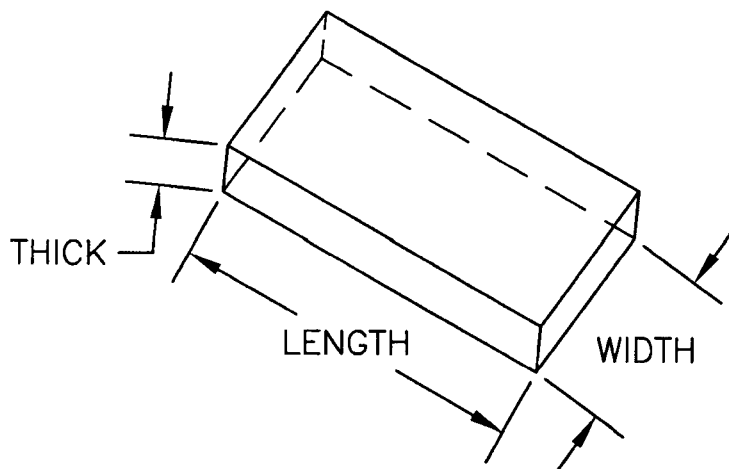
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6102-013P 6061-T6 7.0x6.5x2.0		Purchased	No			110	Each	0.0000	1	40			

*12/21/11 (40)*

**DART**

DESIGN #	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D6102	Rev. D SHEET 1 OF 1
DATE 06.06.30		TITLE SADDLE BILLET, 6061	SCALE NTS
A	01.03.30	NEW ISSUE	
B	03.10.20	ADD D6102-005/-007/-009	
C	04.08.25	ADD D6102-010/-011	
D	06.06.30	ADD D6102-013	

## SPECIFICATION CONTROL DRAWING

**RELEASED**

06.08.15 #

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.06/-0.00), AND GRAIN DIRECTION AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.06/-0.00.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6102-001	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.880	6.250	2.000	Along 7.880 Length
D6102-003	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.000	6.250	2.000	Along 6.000 Length
D6102-005	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	47.85	15.250	1.000	Along 47.85 Length
D6102-007	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.500	7.000	2.500	Along 7.500 Length
D6102-009	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	11.000	6.000	5.000	Along 11.000 Length
D6102-010	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.950	8.250	2.500	Along 7.950 Length
D6102-011	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.500	8.250	2.500	Along 6.500 Length
D6102-013	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.500	7.000	2.000	Along 6.500 Length

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Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO15716

Purchase Order Date 12/21/2011

PO Print Date 12/21/2011

Page Number 1 of 1

Order From :

VC-MET001

METAUX CASTLE  
A.M. CASTLE & CO. (CANADA) INC. - BOX B9204 PO BOX 9100  
TORONTO, ON M4Y 3A5  
CA

Contact Name

Vendor Phone

Vendor Fax

Vendor Account Nbr

514 694 9575

514 695 3281

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Brigitte Golden

10127-2607

Net 30

CAD

Destination-Collect

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D6102-013P	6061-T6 7.0x6.5x2.0	12/23/2011 Yes	40.00 Each		\$34.9000	\$1,396.00

Special Inst: Aluminum Billet  
7.000" X 6.500" X 2.000" THICK  
TOLERANCE IS +0.06/0.00  
GRAIN DIRECTION ALONG 6.500"  
LENGTH  
MAT: 6061-T6/T6511 (QQ-A-250/11 OR  
QQ-A-200/8

PO Total: \$1,396.00

Change Nbr: 1

Change Date: 12/21/2011

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

**Castle Metals®**

A. M. Castle &amp; Co.

## BORDEREAU DE MARCHANDISES

Page 1 of 2

No de Formulaire d'Emballage / Shipment No:1157480

<b>Expédié de / Ship From:</b> A. M. Castle & Co. (Canada) Inc. MONTREAL 835-SELKIRK AVENUE POINTE CLAIRE, QUEBEC H9R 3S2		<b>Vendu à / Sold To:</b> DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		<b>Expédié à / Ship To:</b> <i>Dart Aerospace</i> 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		<b>Livré à / Deliver To:</b> WILL CALL-MONTREAL 835 SELKIRK AVENUE POINTE CLAIRE, QC H9R 3S2 CA			
<b>Date d'expédition / Date Shipped</b>		<b>F.O.B.</b>		<b>Modalités de transport / Freight Terms</b>		<b>Transporteur / Carrier</b>		<b>No du Bon de connaissance / BOL No</b>	
26-JAN-2012		ORIGIN		Prepaid		MANITOULIN		1157480-2	

<b>Détails d'expédition / Shipment Details</b>	<b>Destination finale / Final Destination Branch - MON</b>
--	--

N° de commande / Order No	N° de ligne Line No	N° d'article / Item No	Description	
1931698	1	8641.MO	2.0000.PL.6061.T651.ALUMINUM.48.5000.144.5000 CUT 2SIDED TO 7 IN ( + .0310/- .0000 IN (GRAIN TO RUN ALONG 6.5")) X 6.5 IN ( + .0310/- .0000 IN (GRAIN TO RUN ALONG 6.5")) - ALUMINUM PLATE SAW SPECIFICATIONS: QQ-A-250/11	
N° de bon de commande / Purchase Order No		Nbre de pièces / Part Number	Qté commandée / Ordered Qty	Qté Facturée / Invoice Qty
15716		YOUR ITEM NUMBER: D6102-013	40.00 PCS	40.0000 PCS

<b>Détails / Details</b>							
<b>N° de livraison / Delivery No :</b> 114603329	<b>Usine / Mill</b> KAISER ALUMINUM	<b>No de coulée / Heat Number</b> 557254A0	<b>Code méc / Mech Id</b>	<b>Pièces / PCS</b> 40	<b>Largeur (Pouce)/ Width (IN)</b>	<b>Longueur (Pouce)/ Length (IN)</b>	<b>Qté expédiée/ Shipped Qty(LBS)</b> 364.57

Ces marchandises/technologies sont sujettes aux règlements de l'Export Administration et du département d'état des États-Unis. Si elles ont été/sont exportées, elles doivent se conformer à ces règlements. Toute modification du contrat de transport contraire aux lois des États-Unis est interdite.  
These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.

Nous certifions par la présente que le matériel couvert par cette certification est conforme aux spécifications susmentionnées et aux exigences applicables pour le matériel, y compris toute spécification faisant partie de la description. Les rapports d'essai sont archivés pour fins de consultation. Toute requête concernant du matériel défectueux sera rejetée à moins qu'elle ne soit faite par écrit à A. M. Castle & Co. dans les 60 jours suivant la livraison. Le matériel coupé sur mesure ou coupé par le client ne peut être retourné pour crédit.  
We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

These commodities, technology or software were exported from the United States in accordance with the Export Administration Regulations. Diversion contrary to US law prohibited.

Date Printed: 26-JAN-2012 03:07:39 PM

**SHIP TO:**

AM CASTLE & CO  
3400 NO WOLF ROAD  
FRANKLIN PARK, IL 60131

**KAISER  
ALUMINUM**

Trentwood Works - Spokane, WA 99215

Phone: (800) 367-2586

**CERTIFIED TEST REPORT****SOLD TO:**

AM CASTLE & CO- SOLD TO  
1420 KENSINGTON RD  
SUITE 220  
OAK BROOK, IL 60523

Serial Number

4249792

CUSTOMER PO NUMBER: 143469		WORK PACKAGE:		CUSTOMER PART NUMBER: 8641 AMC A96061-161 R 2		SHIP RUN/LOAD: 102213/22	GOV'T CONTRACT NUMBER:
KAISER ORDER NO: 1127391	LINE ITEM: 1	SHIP DATE: 4-JAN-2012	ALLOY: 6061	CLAD: BARE	TEMPER: T651	PRODUCT DESCRIPTION: KaiserSelect® Precision Plate	
WEIGHT SHIPPED: 9810 LB	QUANTITY: 7 PCS EST.	B/L NUMBER: 2035136	GAUGE: 2.0000 IN	DIAMETER/WIDTH: 48.500 IN		LENGTH: 144.500 IN	

MHU 1554079: LOT 557254A0: 3 pieces;

MHU 1554081: LOT 557254A0: 1 pieces;

MHU 1554764: LOT 573889A3: 3 pieces;

**Certified Specifications**

AMS 4027/RevN

ASME SB 209/Rev2004

ASTM B 209/Rev10

Test Code: 1511

**Test Results**

Lot: 557254A0

Cast 003

Drop 04

Ingot 2

Melted in USA

(ASTM E8/B557)

(EN 2002-1)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T651	LT / 2 (Min:Max)	48.3 : 49.4 (333 : 341)	43.0 : 44.1 (296 : 304)	13.7 : 14.1

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.71	0.5	0.31	0.07	1.1	0.18	0.04	0.02	0.01	0.00	TOT 0.04

# KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215  
Phone: (800) 367-2586

## CERTIFIED TEST REPORT

Serial Number  
4249792

Lot: 573889A3 Cast 845

Drop 11

Ingot 1

Melted in USA

(ASTM E8/B557)  
(EN 2002-1)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T651	LT / 2 (Min:Max)	49.4 : 50.6 (341 : 349)	45.3 : 46.1 (312 : 318)	13.9 : 14.1

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual -	0.71	0.5	0.33	0.08	1.0	0.18	0.19	0.02	0.01	0.00	TOT 0.04

### ALLOY LIMITS

	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
6061												
MIN	0.40	0.0	0.15	0.00	0.8	0.04	0.00	0.00	0.00	0.00	EACH	0.05
MAX	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.05	TOT	0.15

Aluminum Remainder

### TEST NOTES

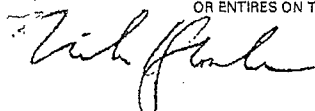
6061 sheet or plate certified to AMS 4025, AMS 4026, or AMS  
4027 also meets applicable requirements of AMS-QQ-A-250/11  
Rev.A.

Castle Metals FP

HEAT NUMBER 557254A0  
MECHANICAL ID \_\_\_\_\_  
ITEM CODE 8641  
LOT NUMBER \_\_\_\_\_  
PO NUMBER 143469  
RECEIPT DATE 1-9-12  
SUPPLIER KAISER  
SPECIFICATION \_\_\_\_\_  
LCS 10  
COMMENT \_\_\_\_\_  
APPROVED DL

### CERTIFICATION

KAISER ALUMINUM FABRICATED PRODUCTS, LLC (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED IN THE UNITED STATES OF AMERICA OR A QUALIFYING COUNTRY PER DFARS 225.872-1(a), WAS MANUFACTURED IN THE UNITED STATES OF AMERICA, AND MEETS THE REQUIREMENTS OF DFARS 252.225 FOR DOMESTIC CONTENT. THIS MATERIAL HAS BEEN INSPECTED, TESTED, AND FOUND IN COMPLIANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF KAISER ALUMINUM FABRICATED PRODUCTS, LLC LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR ENTIRE ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED.



MIKE KLOCKE, LABORATORIES SUPERVISOR